

Date: Thursday, 6/29/2006 8:28:12 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SUPPORT BRACKET
Job Number : 27765	
Estimate Number : 10260	
P.O. Number : N/A	Part Number : D23623
This Issue : 6/29/2006 S.O. No. : N/A	Drawing Number : D2362 REV E1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : E1
Previous Run : 27309	Material : N/A
Written By : <i>See Comment Below</i>	Due Date : 7/30/2006
Checked & Approved By : <i>060629</i>	Qty: 10 Um: Each
Comment : Est: G 0003.18 Added inspection level 8 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2265	Step Support Casting
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Step Support

Pick:

Qty	Part Number	Description	Batch
1	D2265	Step Support	<i>B25401</i>

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: Machine per folio D2362-3

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: Inspect Level 2

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Debutr

6.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Gloss White (Ref 4.3.5.1) as per Dart QSI 005 4.3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DP Date: 06/08/0

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 6/29/2006 8:28:12 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT BRACKET

Job Number: 27765

Part Number: D23623

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

8.0

D23971

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1

D2397-1

Rubber

B25469 (1mx) B27768 (9mx)

9.0

D23973

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1

D2397-3

Rubber

B25470 (1mx) B27769 (9mx) MF 06/08/08

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bond rubber D2397-1 followed by D2397-3 using contact cement

as per Dwg D2362

Batch M16194

MF 06/08/03 (10)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-08-04 (10)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST173

06/08/08 (10)

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/08/09 (10)

Job Completion



W 06/08/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART



RELEASED
98.12.14 KE

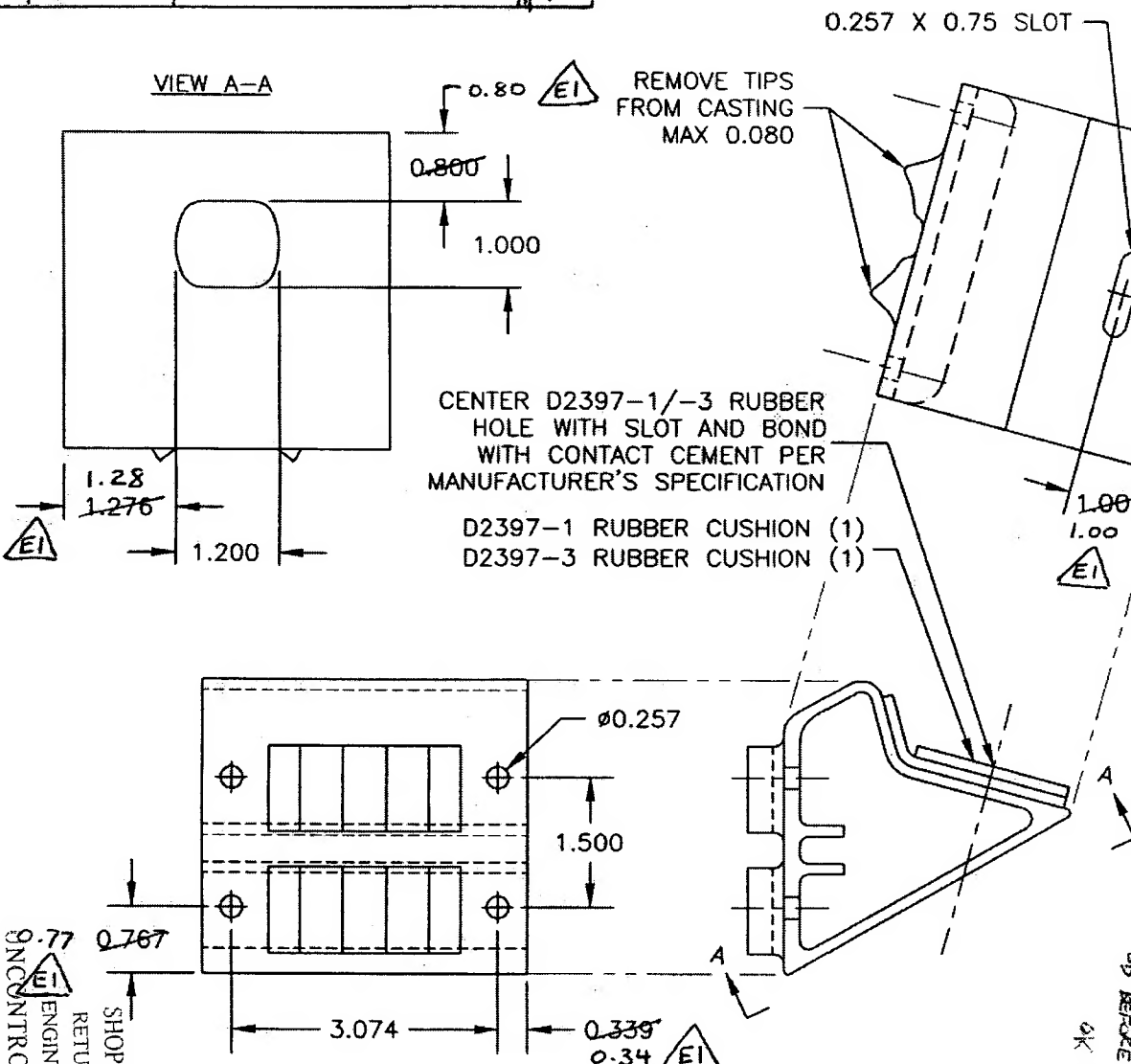
DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	CP	D2362
DATE	TITLE	REV. E
98.12.04	STEP SUPPORT BRACKET	SHEET 1 OF 3
		SCALE
		1:2
A	95.02.15	NEW ISSUE
B	95.03.22	CHANGED RUBBER TO D2397
C	96.01.22	ADD D2362-5
D	97.05.21	ADD D2362-7
E	98.12.04	REDRAWN, ADD 2397-5

UNDER REVIEW

01.03.15 CP

DESIGN OK, BUT CHECK WITH
D23 BEFORE MANUFACTURE
OK 01.11.04

D2362-3



NOTES:
MAKE FROM D2265
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING
RUBBER IN PLACE
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

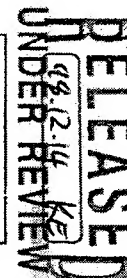
Copyright 1995 by DART AEROSPACE LTD

WITHOUT NOTICE
WORK ORDER
NO. 27765

77
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

QA CONTROL ISSUED

DESIGN	DRAWN BY		DART AEROSPACE LTD	
BW	<i>CP</i>		HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E	
<i>KE</i>	<i>[Signature]</i>	D2362	SHEET 2 OF 3	
DATE	TITLE		SCALE	
98.12.04	STEP SUPPORT BRACKET		1:2	



DESIGNER, BUT CHECK W/ US BEFORE MANUFACTURE

OK
Feb. 11. 09

MAKE FROM D2265
D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT
AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3
BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WITHOUT NOTICE

WORK ORDER
NO. 27765

D2362-041 (SHOWN)

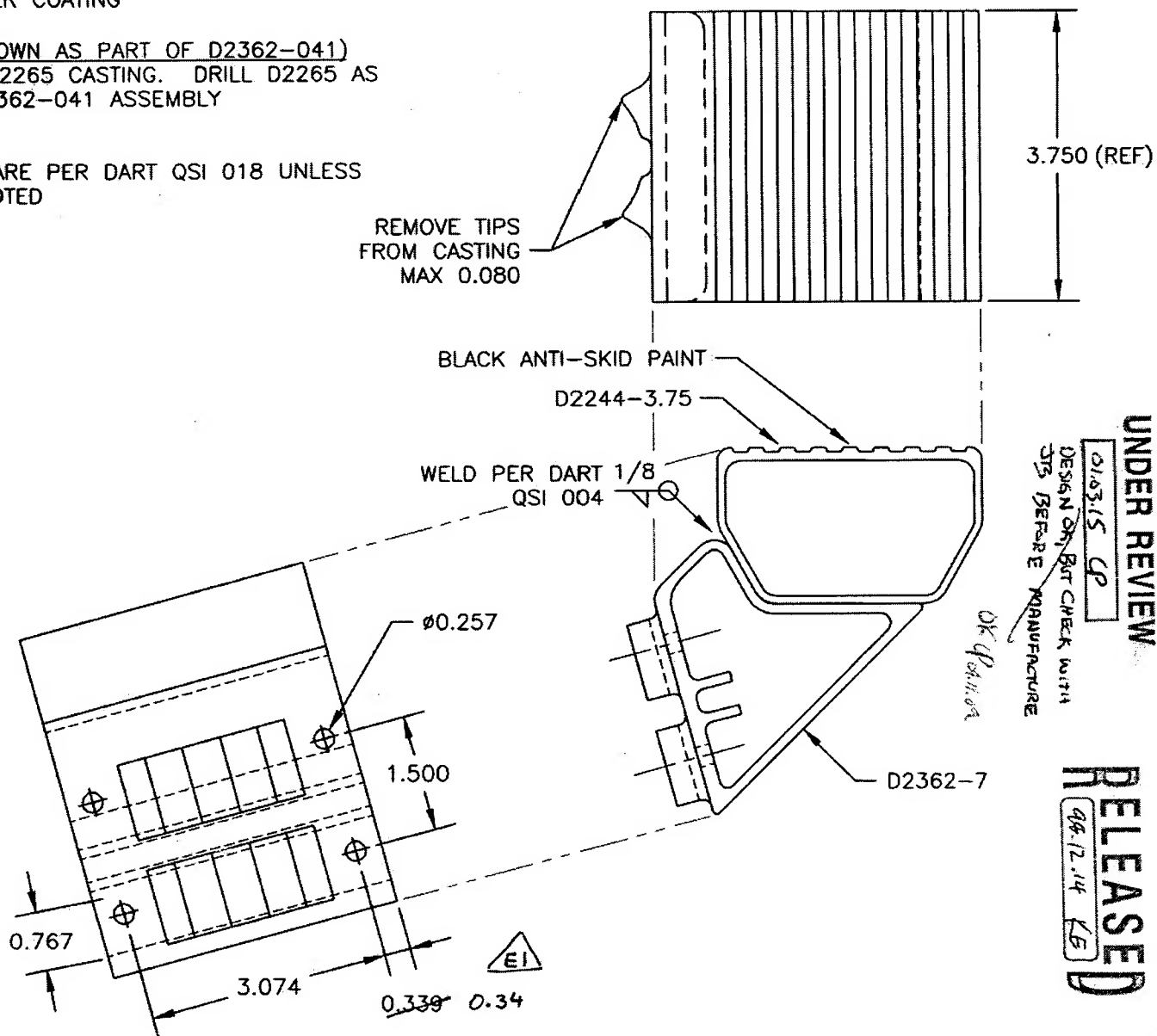
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER
QSI 005 4.3
ANTI-SKID PAINT PER QSI 005 4.4 AFTER
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)

MAKE FROM D2265 CASTING. DRILL D2265 AS
SHOWN IN D2362-041 ASSEMBLY

NOTES:

TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED



UNDER REVIEW

RELEASED
46.12.14 KB



DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. E
BW	APPROVED	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DATE	DRAWING NO.	SHEET 3 OF 3
98.12.04	98.12.04	D2362	1:2
		STEP SUPPORT BRACKET	SCALE

